

Title (en)

Brass for controlling the welding parameters in order to weld two metallic workpieces

Title (de)

Verfahren zum Regeln von Schweißparametern zum Schweißen von zwei metallischen Werkstücken

Title (fr)

Procédé de réglage de paramètres de soudage pour la réalisation d'un joint de soudure entre deux pièces métalliques

Publication

EP 0765709 B1 19990107 (FR)

Application

EP 96401999 A 19960919

Priority

FR 9511409 A 19950928

Abstract (en)

[origin: EP0765709A1] Regulating the welding parameters for producing a weld joint between two metal components (1,2) by filling a chamfer (3) involves determining for each of the filling layers (6, 6n-1, 6n) in the chamfer (3) the following parameters: (a) the width of the base (Lic) of the layer (6n) between the first and second edges (1a,2a) of the chamfer; (b) the number of weld passes needed to produce the layer (6n); (c) a real remaining width (Lr) for the layer (6n) by subtracting from the base width (Lic) a predetermined fixed value (Lif) corresponding to the optimal width of the final weld ribbon in contact with the second edge (2a) of the layer (6n); (d) an initial value (Lin) for the remaining width; (e) a relationship (R) between the real remaining width (Lr) and the initial value (Lin) of the remaining width is calculated; and (f) the speed of advance of the welding head during successive passes for the production of the layer (6n) and the staggering of the welding head in the direction transverse to the chamfer (3) between two successive passes.

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